

Date: Friday, 3/9/2007 10:29:28 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE 412
Job Number	: 31137		
Estimate Number	: 12783		
P.O. Number	: N/A	Part Number	: D412664145
This Issue	: 3/9/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D412-664-245 YR OK 07.03.09
First Issue	: N/A	Project Number	: N/A
Previous Run	:	Drawing Revision	: U/R
Written By	:	Material	: N/A
Checked & Approved By	: <u>07.03.09</u>	Due Date	: 4/6/2007
Comment	: Est Rev.A New Issue 07-02-14 JLM	Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPPD412-664-105 CHG 001

2.0	D6019128	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6019-128 Crosstube 29369

Check OD = 2.7500"; ID = 2.125

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Dwg D412-664-145

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



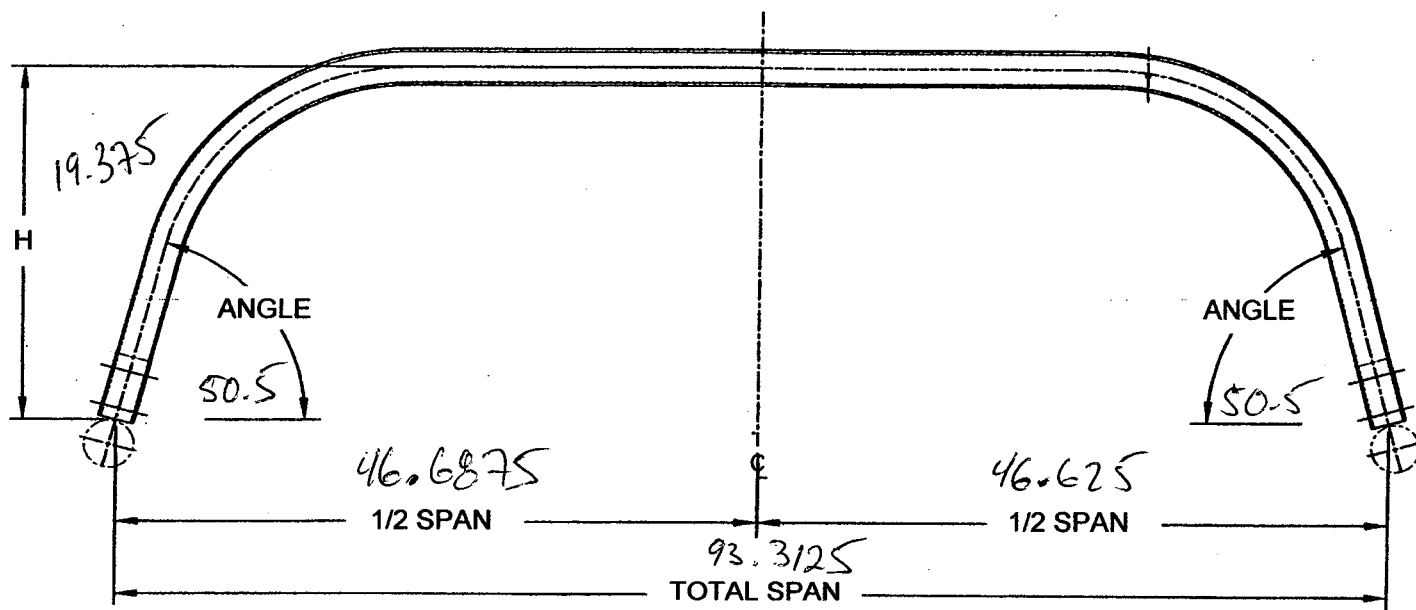
Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

DP 7-3-12

7

Crosstube Bend Dimension Sheet



PART NUMBER: D412-664-145

BATCH NUMBER: B31137

DRAWING: D412-664-145 REVISION: B

H: 19.36 ±.130

1/2 SPAN: 46.6 ±.130

TOTAL SPAN: 93.2

ANGLE: 50°

QC 15: [Signature]

DATE: 0703.12

QTY: 1



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36061

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of seven (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D412-664-145 S/N's B31137 & B31138

Qty. (1) P/N D206-667-103 S/N B30428

Qty. (2) P/N D412-664-203 S/N's B30427 & B30425

Qty. (2) P/N D206-667-101 S/N's B30439 & B30437

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on seven (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Seven (7) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: _____

DATE March 29, 2007

INSPECTION STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

3440

ADDRESS:

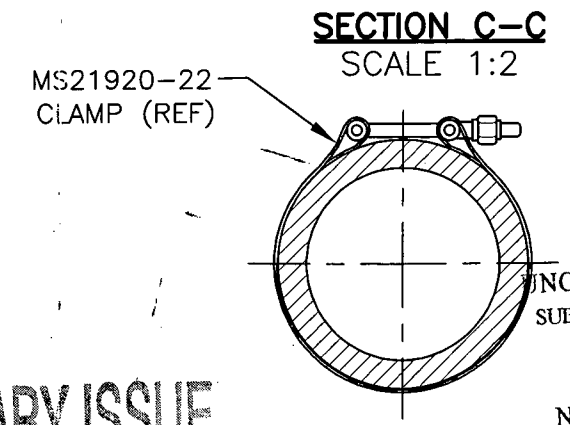
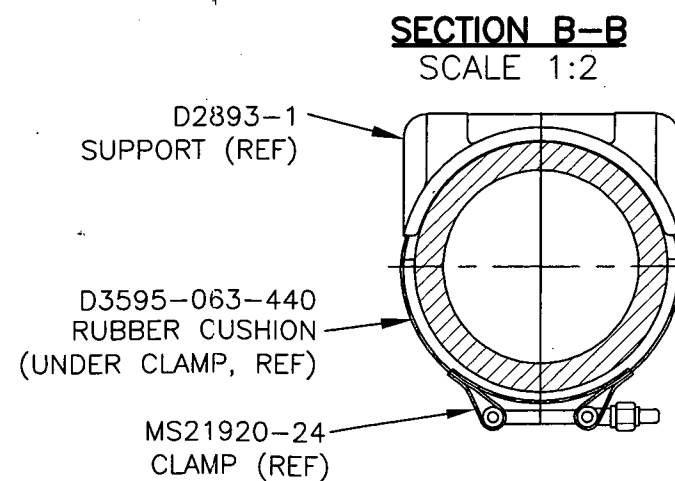
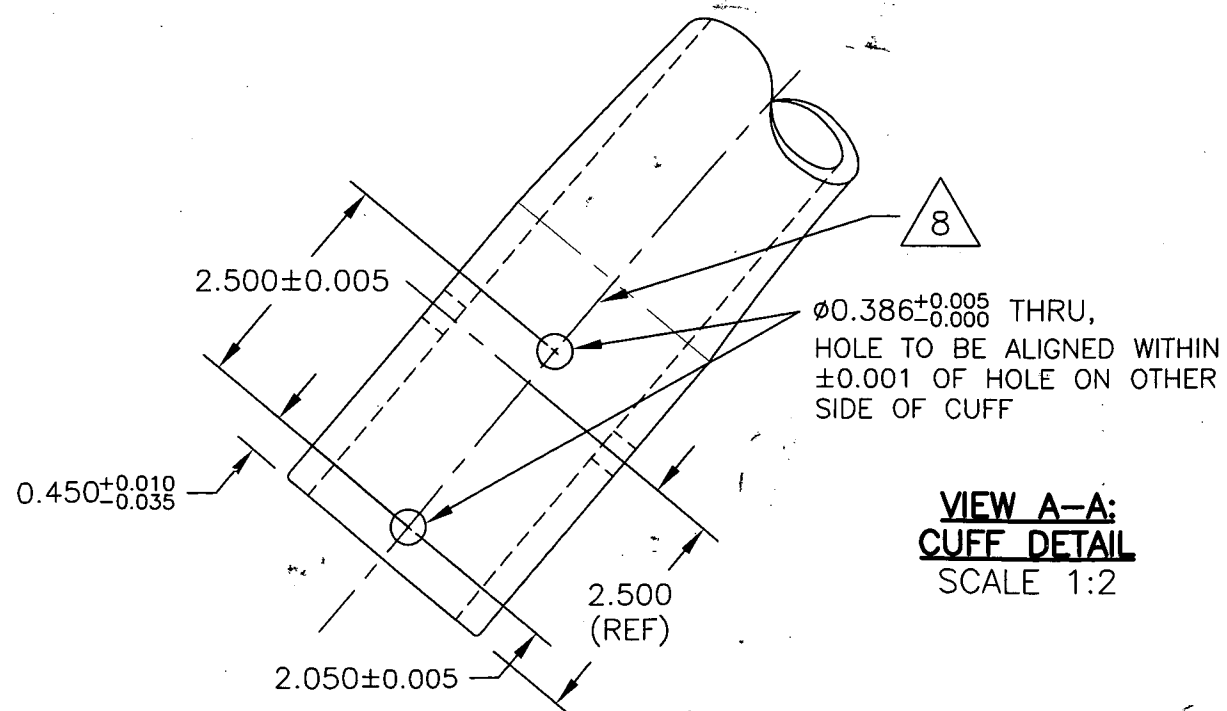
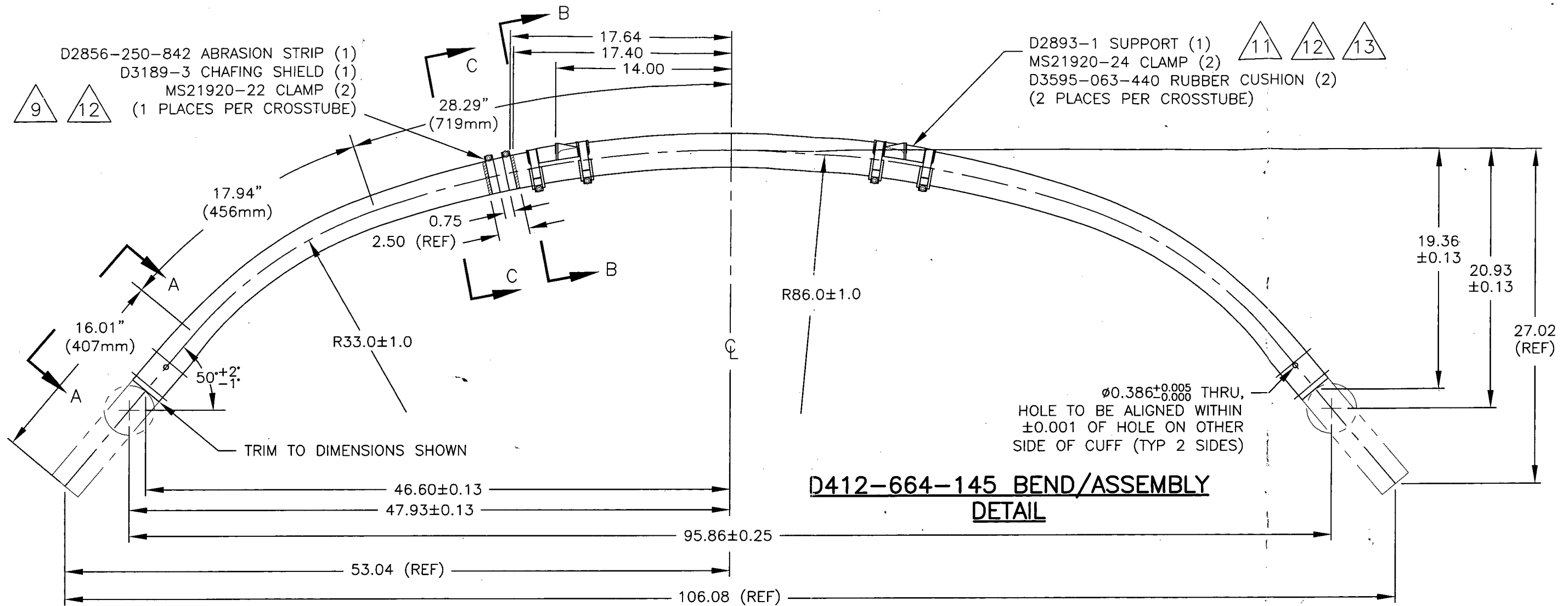
CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



PRELIMINARY ISSUE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31131

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN qp	DR/WN BY qp	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D412-664-145	REV. B SHEET 2 OF 3
DATE 07.03.01	TITLE CROSSTUBE (412 LOW-NARROW FWD)	SCALE 1:8	

